



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3594-043
Job Sheet 177158



Part No: D3594-043

Job Qty: 6 ea

Part Name: Floor Doubler Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 5/28/18

Created By: Marie Lajeunesse

Type: ~~Stock~~ **SOLD**

Description:

Note: DWG REV D SHEETS 3,4 IPP Rev :A New Issue 07-01-22 EC IPP REV:B 16.07.28 DWG REV:C DD
VERF:JLM IPP REV:C 17.04.27 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	5/28/18	5/28/18	0.00	0.00	Start Up Waterjet		
100	Waterjet	6 pcs	5/28/18	5/28/18	0.00	2.48	Waterjet1		
110	QC	6 pcs	5/28/18	5/28/18	0.00	0.00	QC2 Waterjet-2		
120	QC	6 pcs	5/28/18	5/28/18	0.00	0.00	QC8-3		DAS 38
130	Small Fab	6 pcs	5/28/18	5/28/18	0.00	0.31	Small Fab-4		9-89 DAS 38
140	QC	6 pcs	5/28/18	5/28/18	0.00	0.00	QC5		38
150	HandFinish	6 pcs	5/28/18	5/28/18	0.00	0.21	HandFinish1		SA 18-05-31
160	QC	6 pcs	5/28/18	5/28/18	0.00	0.00	QC7-2		
170	Small Fab	6 pcs	5/28/18	5/28/18	0.00	0.31	Small Fab-4		
180	QC	6 pcs	5/28/18	5/28/18	0.00	0.00	QC5		JUN 04 2018
190	Packaging	6 pcs	5/28/18	5/28/18	0.00	0.00	Packaging3-1		JUN 06 2018
200	QC21-SA	6 Ea	5/28/18	5/28/18	0.00	0.00	QC21		JUN 06 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	3.0600 sf (.51 ea)	90-Start up Operation	
MS20426AD4-4	Rivet	12 Ea (2 ea)	170-Small Fab	
MS21069-5	Anchor Nuts	6 Ea (1 ea)	170-Small Fab	FM125445-4 5030043

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	3	71	0
170-Small Fab	MS20426AD4-4	12	1,102	0
	MS21069-5	6	18	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Supervisor _____ ification Director _____ al Wrong _____ ensions tolerance _____ ct ssing _____ ssing Dart Aerospace Ltd. 1270 Aberdeen Street Hewesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospa.com	

Root Cause

Environment	☐	No Re-verification	☐	Pressure/Forced	☐
Design	☐	Operator	☐	Bending	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Conce	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Rippl	☐
Material	☐	Use for Testing	☐	Cuffs	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐
Past Expiry Date	☐	Manufacturing Process	☐		
Misidentified	☐	Past Due	☐		

OTHER : _____

Part: D3594 - 043

Job No: 177158

Serial No/Batch: S073850

Inspector: _____

Date: 06/23/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					